

Work Order ID 123442***123442***

Page 1

Thursday, August 07, 2014 11:15:42 AM

Item ID: D3575-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cargo Floor Protector

Stop

NS2

Start Date: 8/04/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/07/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:	Process Plan: <u>MLJ</u>	Date: <u>14-08-08</u>	Tooling:	Date: _____	Run	Start	*NR1*
QC:	_____	Date: _____	SPC (Y/N):	Date: _____	Stop	_____	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3575	Rev A								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	***TEXTURE SIDE UP*** 1-Cut as per Dwg D3575								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110	Memo	0.00							
QC									
Quality Control									

① 14/10/14① 14/10/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General					
Bending		Bend		Folio/Program		Outside Dimensions	
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance	
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect	
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing	
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved	
Crushing		Countersink		Misaligned/off center		Positioned Wrong	
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge	
Inspection Strip in Tube		Drawing		Misread		Pressure/Forced	
Marks/Chatter		Drill Holes		Off-set		Set-up	
Turning Sequence		Finish		Out of Calibration		Temperature/Cure	
Wave/Twist in Tube		Fit/Function		Out of Sequence		Weld	
						Wrong Stock Pulled	
						Other	

Work Order ID 123442

123442

Page 2

Thursday, August 07, 2014 11:15:42 AM

Item ID: D3575-2 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Cargo Floor Protector Stop *NS2*

Start Date: 8/04/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 8/07/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC8- Inspect parts - second check Memo	0.00				1			DAS 38 9-89 14-10-16
150 *150* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00							OCT 15 2014 DAS 06
160 *160* QC	QC21- Final Inspection - Work Order Release Memo	0.00							14/10/16 CMF 14-10-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>
Centre Not Concentric	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>
Cracks	Broken/Damage/Defect	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>
Cuffs	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>
Crushing	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>
Heat Treat	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>
Inspection Strip in Tube	Drawing	<input type="checkbox"/>	Other	<input type="checkbox"/>
Marks/Chatter	Drill Holes	<input type="checkbox"/>		
Turning Sequence	Finish	<input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function	<input type="checkbox"/>		

Picklist Print

Page 1

Thursday, August 07, 2014 11:15:42 AM

Work Order ID: 123442

123442

Parent Item: D3575-2

D3575-2

Parent Item Name: Cargo Floor Protector

Start Date: 8/04/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	5,710.525	8	10		**	

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	MAT019	3150.525	
	124866	106	
	m126425	160.925	
	m127934	699.6	
	m128746	2184	
TPI		2560	64
	m129759	2560	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General					
Bending		Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>		
Centre Not Concentric		BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>		
Cracks		Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>		
Crimp/Kink/Ripple/Wave		Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>		
Cuffs		Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>		
Crushing		Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>			
Heat Treat		Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>		
Inspection Strip in Tube		Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>				
Marks/Chatter		Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>				
Turning Sequence		Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>				
Wave/Twist in Tube		Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>				

DART AEROSPACE LTD		Work Order: <u>123442</u>
Description: Cabin Floor Protector		Part Number: D3575-2
Inspection Dwg: D3575	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	<u>Ø 3.001</u>	✓		U=JKM-01	
1.00	+/-0.030	<u>1.00</u>	✓		T=JKM-06	
3.50	+/-0.030	<u>3.50</u>	✓			
16.00	+/-0.030	<u>16.00</u>	✓			
23.13	+/-0.030	<u>23.13</u>	✓			
26.88	+/-0.030	<u>26.88</u>	✓			
27.69	+/-0.030	<u>27.69</u>	✓			
4.25	+/-0.030	<u>4.25</u>	✓			
9.63	+/-0.030	<u>9.63</u>	✓			
16.13	+/-0.030	<u>16.13</u>	✓			
28.06	+/-0.030	<u>28.06</u>	✓			
32.15	+/-0.030	<u>32.15</u>	✓			
2.00	+/-0.030	<u>2.00</u>	✓			
3.50	+/-0.030	<u>3.50</u>	✓			
14.25	+/-0.030	<u>14.25</u>	✓			
25.13	+/-0.030	<u>25.13</u>	✓			
29.38	+/-0.030	<u>29.38</u>	✓			
30.13	+/-0.030	<u>30.13</u>	✓			
1.25	+/-0.030	<u>1.25</u>	✓			
3.38	+/-0.030	<u>3.38</u>	✓			
5.00	+/-0.030	<u>5.00</u>	✓			
6.50	+/-0.030	<u>6.50</u>	✓			
26.13	+/-0.030	<u>26.13</u>	✓			
31.50	<u>DAS</u> <u>38</u>	<u>+/-0.030</u>	<u>31.50</u>	<u>DAS</u> <u>38</u>	<u>DAS</u>	

Measured by:	<u>DC</u> <u>14/10/14</u>	Audited by:	<u>989</u> <u>989</u>	Prototype Approval:	N/A
Date:		Date:	<u>14-10-16</u>	Date:	N/A

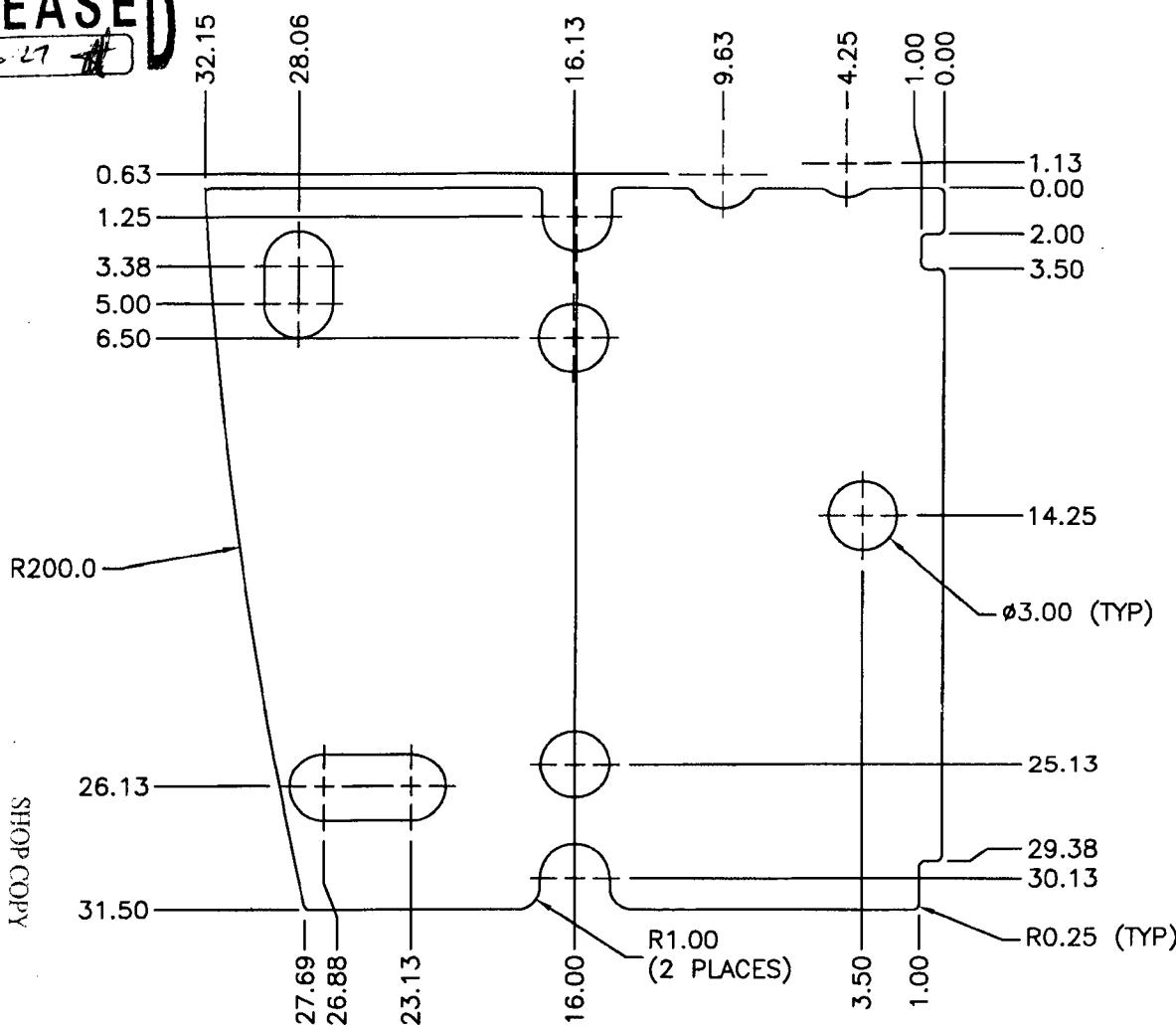
Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	<u>DS</u>



DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>CE</i>	APPROVED <i>#</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4	
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8	
A	07.06.08	NEW ISSUE		

RELEASED
07-06-27 ~~1~~

07



D3575-1 CABIN FLOOR PROTECTOR (SHOWN)
D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)

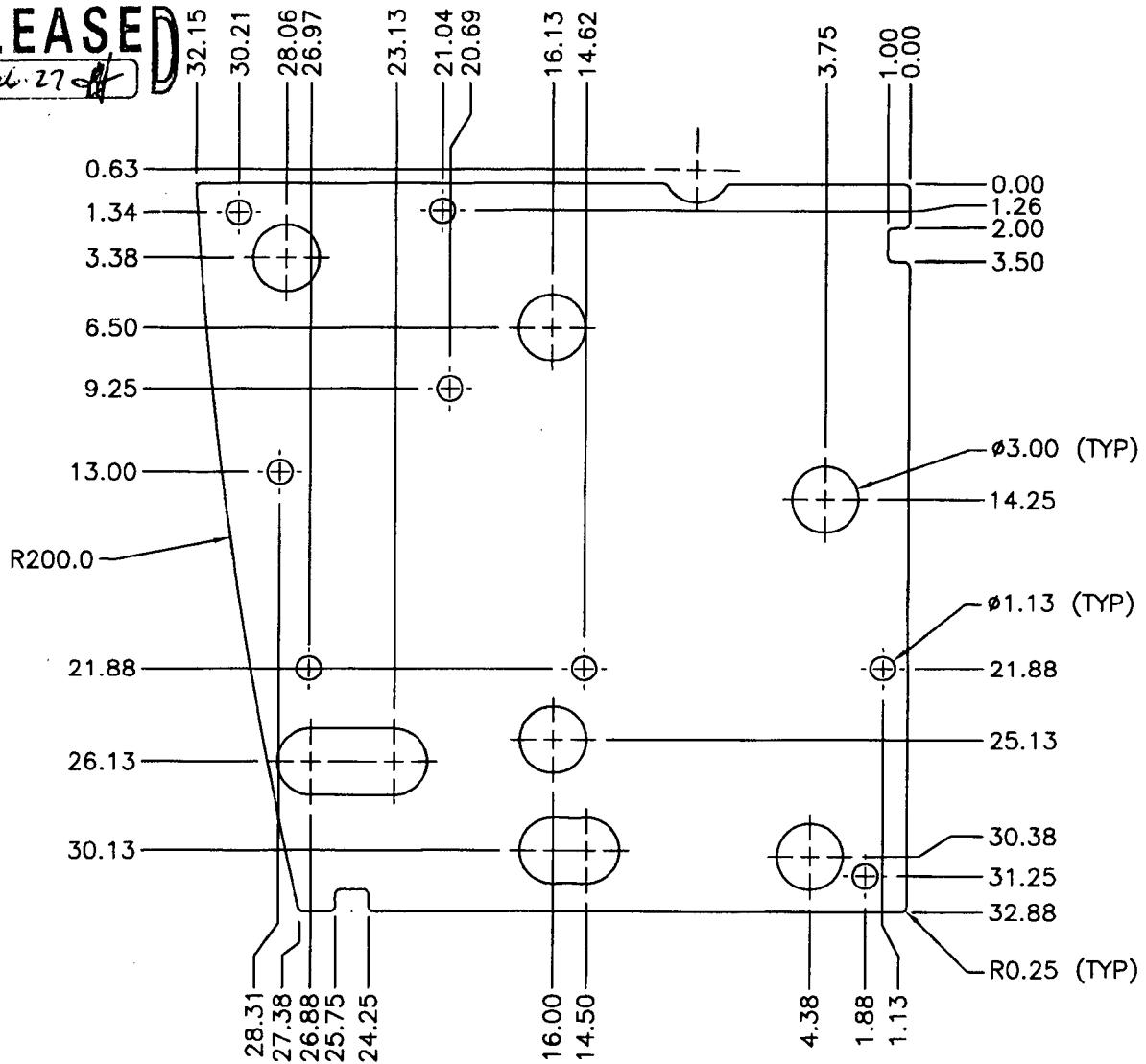
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966



DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>W</i>	DRAWING NO. D3575	REV. A SHEET 2 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED
07.06.27 *W*



D3575-3 CABIN FLOOR PROTECTOR

NOTES:

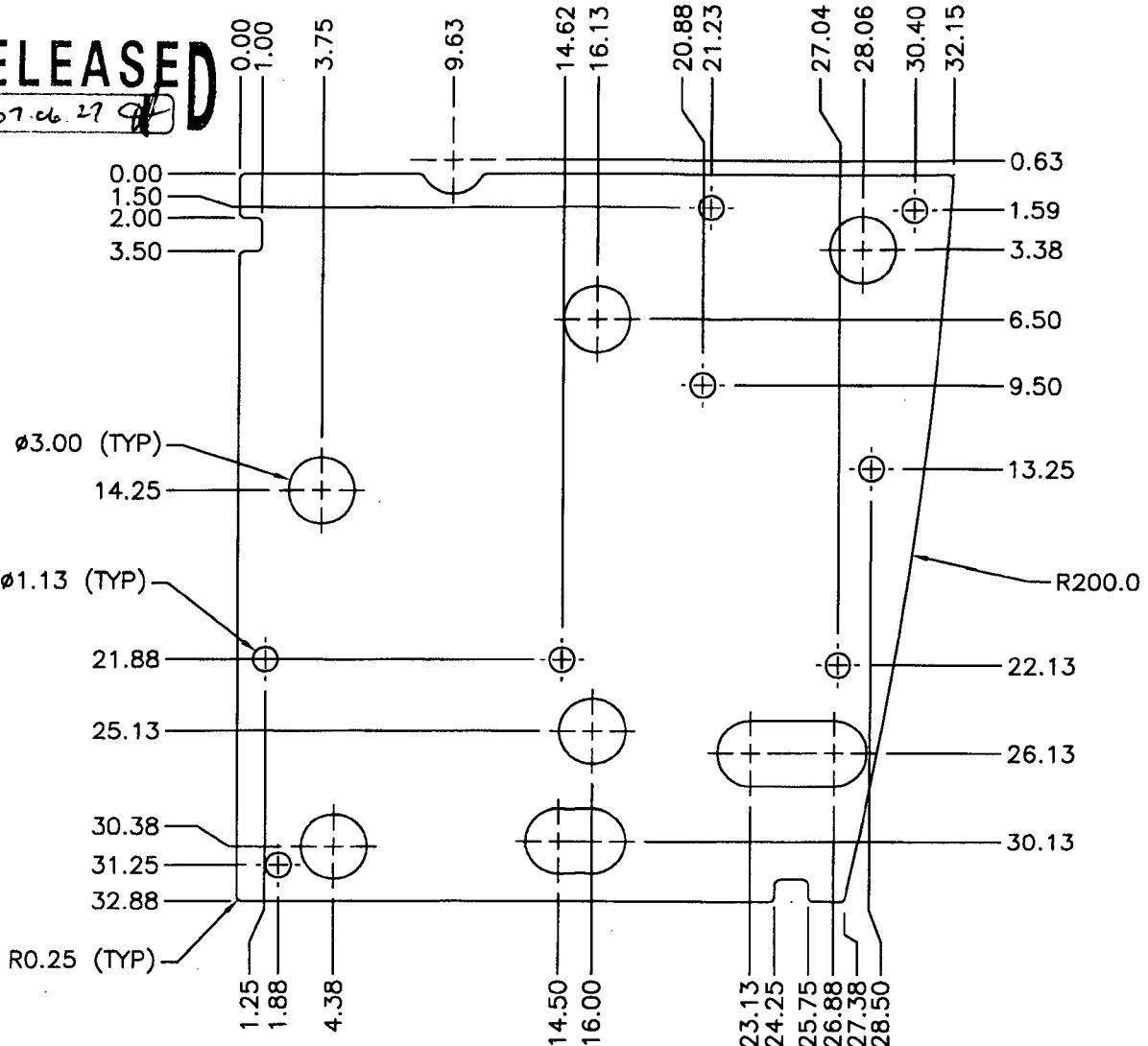
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

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DART

DESIGN <i>CE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D3575	REV. A SHEET 3 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED
07.06.08**D3575-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

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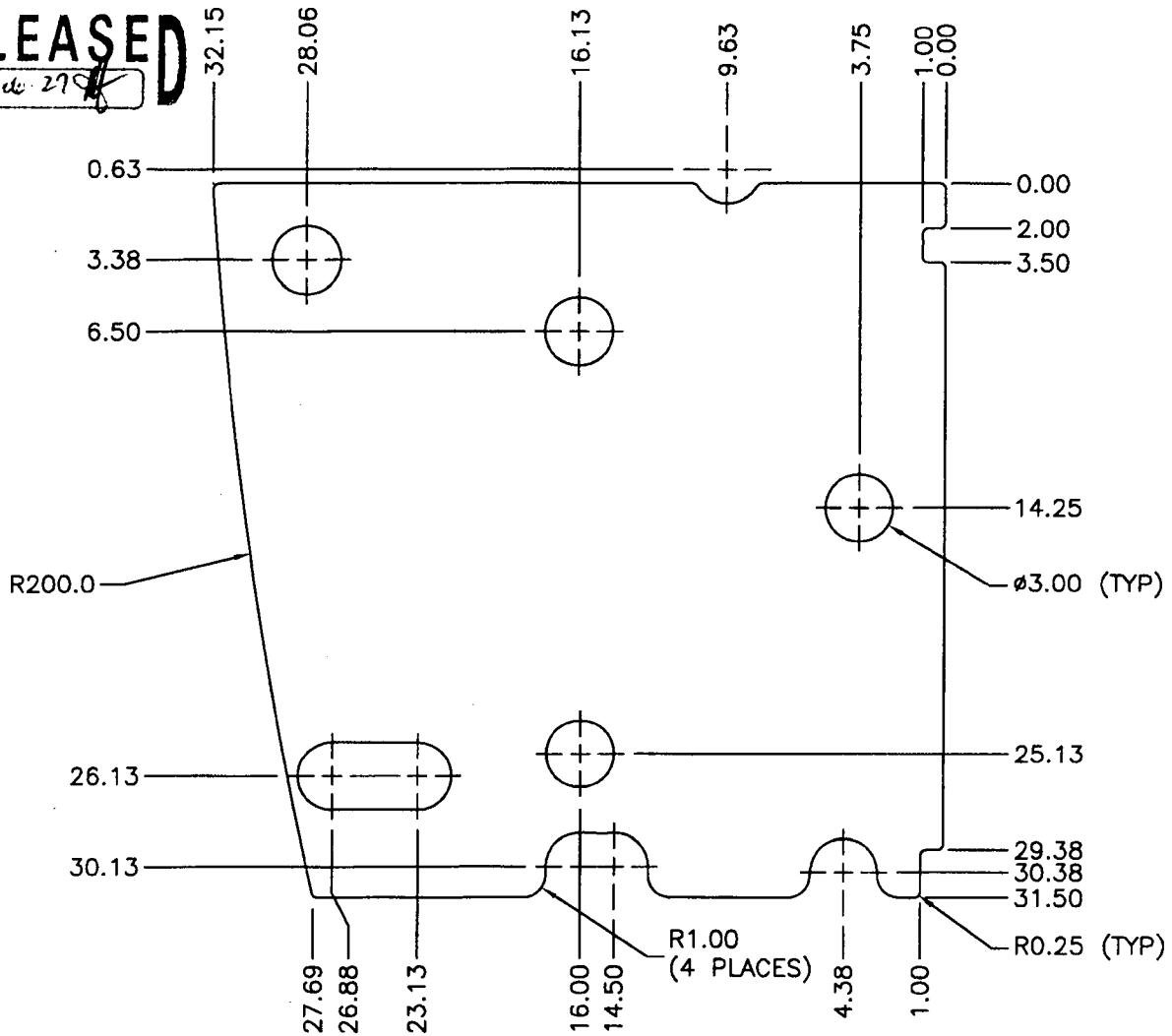
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DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

RELEASED

07 de 27/08

**D3575-5 CABIN FLOOR PROTECTOR (SHOWN)****D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969